Qty:

: 205 SKIDTUBE "I" BEAM

: D2596

: N/A

: D

. D2596 REV D

: 24/01/2008

Date:

Thursday, 17/01/2008 3:13:12 PM

User:

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 36872

: 10346

P.O. Number

This Issue : 17/01/2008

Prsht Rev. : NC

: //

First Issue : 36803 **Previous Run**

Written By

Checked & Approved By

Comment

: Est: D 99.02.02

Type

Changed QA to QC, Added Step 6 and Cost

S.O. No. :

М

Est Rev:E 07-07-09 Incorperated DEO 9183 JLM

: LANDING GEAR

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

Ext'n - I' Beam Web 4"

1.0 D25003100

Comment: Qty.:

1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick:

Qty

Part Number

D2500-3-100

Description Extrusion ...

8-1-21

10 Um:

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1





Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5"

2- Use Jig DT8093 to drill pilot holes #30

3- Open to 0.630" diameter as per Dwg D2596

4- Deburr

9-1-21

3.0

HAND FINISHING1



Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1

4.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

Page 1

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		WORK ORDER CHANGES								
STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A: L	<u>ک</u> Date: <u>ح</u>	8611618		
•				QA: N	N/C Close	d:	_ Date: _			
		WORK ORD	ER NON-CONFORMA	NCE (NC	₹)					
STEP	Description of NC Section A	Corrective Action Section B			Verific	cation	Annroval	Approval		
		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	💃 Sect		Chief Eng	QC Inspector		
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	STEP	:PAR #:	STEP PROCEDURE CHAR PAR #: Fault Cate WORK ORDI STEP Description of NC Section A Initial	WORK ORDER CHANGE PROCEDURE CHANGE Fault Category: WORK ORDER NON-CONFORMAL WORK ORDER NON-CONFORMAL STEP Description of NC Section A Initial Action Description	WORK ORDER CHANGES STEP PROCEDURE CHANGE By :PAR #:Fault Category:NCR: Yes QA: N WORK ORDER NON-CONFORMANCE (NCF STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DQ QA: N/C Close WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty :PAR #: Fault Category: NCR: Yes No DQA: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng/Prod Mgr :PAR #:Fault Category:NCR: Yes No DQA: Date: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Section C Section C Section C Section C Section C Section C Chief Eng Approval Chief Eng Corrective Action Description Sign & Section C Chief Eng Chief Eng Chief Eng Corrective Action Description Sign & Section C Chief Eng Ch		

NOTE: Date & initial all entries

Date: Thursday, 17/01/2008 3:13:12 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: 205 SKIDTUBE "I" BEAM Job Number: 36872 Part Number: D2596 Job Number: Seq. #: Machine Or Operation: Description: PACKAGING 1 PACKAGING RESOURCE #1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG SL 8-1-23 FINAL INSPECTION/W/O RELEASE QC21 6.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHANG	GES	········			* ·	
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:		Fault Category: NO			CR: Yes No DQA: Date:					
						QA:	N/C Close	d:	_ Date: _	
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE	(NC	R)	·		
DATE	STEP	Description of NC Section A	Corrective Action Section B		tion B		Verific	ration	Approval	Approval
			Initial Chief Eng	Action Description Chief Eng		Sign Date	& Secti		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

涺 DOCUMENT ß **DETAIL A**SCALE 1:4 PRIVATE AND CONFIDENTIAL OR COMMUNICATED 1 Copyright @ 1996 by DART AEROSPACE LTD

L AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR
TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. 1.750 3.500 1.750 0.50 Ø0.63 REFER TO 0.50 (REF) (22 PLACES) DETAIL A CHECKED 07.04.17 - 1.750 O 0 ϖ \triangleright P REFER TO DETAIL A 8.75 98.09.14 07.04.17 97.07.23 96.09.16 17.38 32.75 (REF) EQUAL SPACES 8.19 PITCH 26.00 DRAWING NO. 205 42.38 ø0.63 INCORPORATED INCORPORATED NEW ISSUE /D/ 46.01 WEB 50.56 HOLE /D/ 85.59 WAS AEROSPACE L DEO DEO 8 99.50 9183 9097 ¥ PURPOSE **D2596 WEB** MATERIAL: MAKE FROM D2500-3-100 EXTRUSION 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 A H SHEET ဒ္ဓ 3) DIMENSIONS ARE IN INCHES COPIED 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED - 욱 SCALE 5) DEBURR SHARP EDGES 0.010 TO 0.020 1:20

